

Date: Wednesday, 25/06/2008 8:11:58 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE GUIDE
Job Number	: 39964		
Estimate Number	: 10486		
P.O. Number	:	Part Number	: D34403
This Issue	: 25/06/2008 S.O. No. :	Drawing Number	: D3440 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 19/06/2008 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 35547	Material	:
Written By	: <u>JL 06.06.25</u>	Due Date	: 07/07/2008 Qty: 5 Um: Each
Checked & Approved By	:		
Comment	: Est. A 05.07.13 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
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Comment: Qty.: 0.3457 f(s)/Unit Total: 1.7283 f(s)  
 6061 T6 1.25 X 1.25"  
 Material: 6061-T6 or 6061-T651/T6510/T6511/T62 Bar (QQ-A-225/8)  
 (M6061T6B1.250x01.250)  
 Identify for D3440-3

JL 08/06/25 (5)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blank 3.950" long

M106259

JL 08/06/25 (5)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA538 and Dwg D3440  
 Identify as D3440-3  
 Deburr

Dwg Rev: A  
 Folio Rev: AA

ML 08/06/27 (5)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 08/06/27 (5)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE GUIDE

Job Number: 39964

Part Number: D34403

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/07/01 (KS)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l 08/07/02

(SX)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

4:00

OVEN TEMPERATURE:

320

FINISH TIME:

4:30

HL 12/10

(SX)

08/07/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 08-07-14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Pat E.

mf 08-07-14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/15

Job Completion



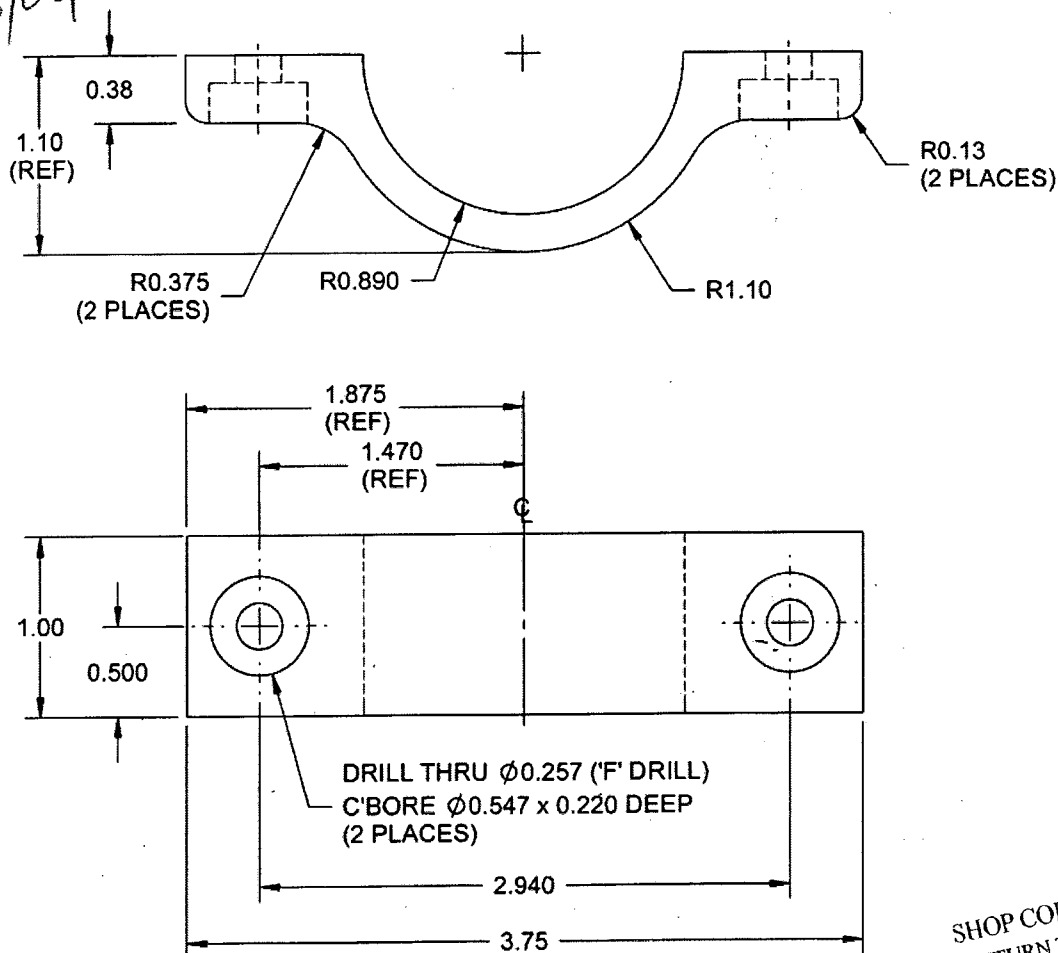
mf 08-07-14



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CHECKED	APPROVED	DRAWING NO. <b>D3440</b>	REV. A SHEET 2 OF 7
DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:1

**RELEASED**  
05/08/18



**D3440-3 CLAMP**  
**SUPERSEDES PREMIER P/N B67-43001-309**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **39964**

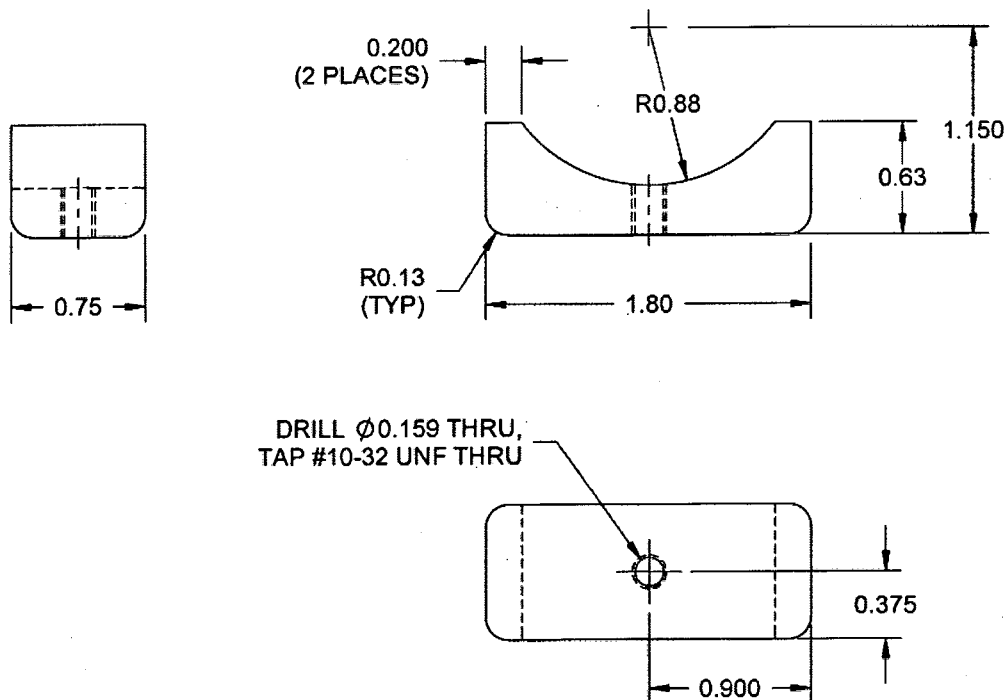
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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*[Signature]*  
05/08/18



**D3440-5 CONTOURED DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-217**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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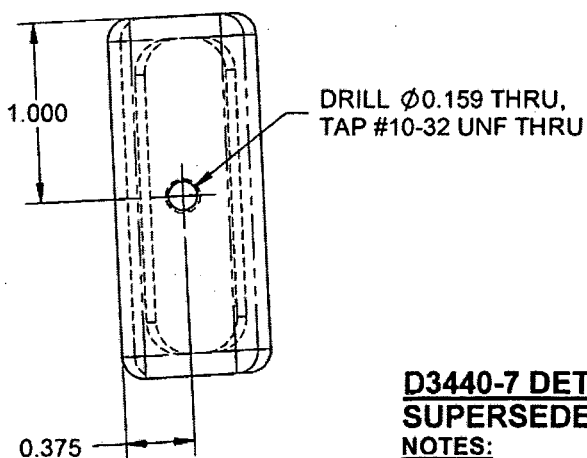
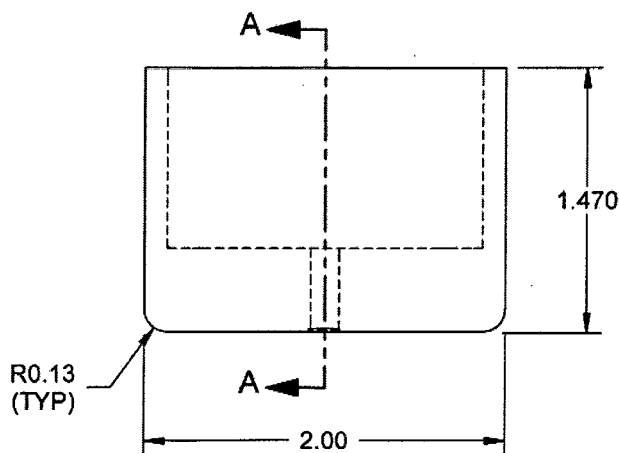
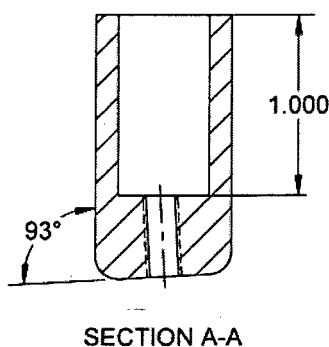
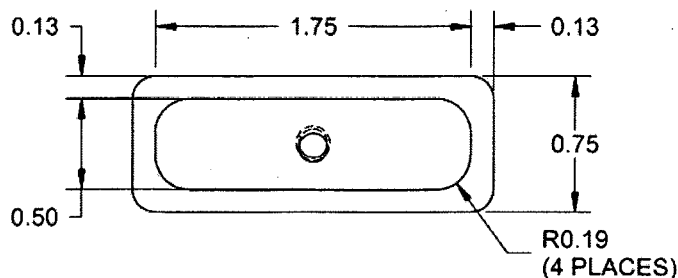
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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**D3440-7 DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-221**

**NOTES:**

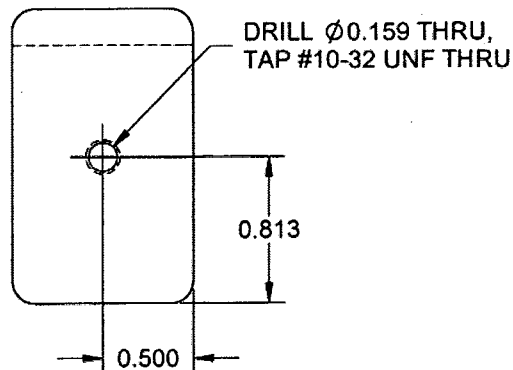
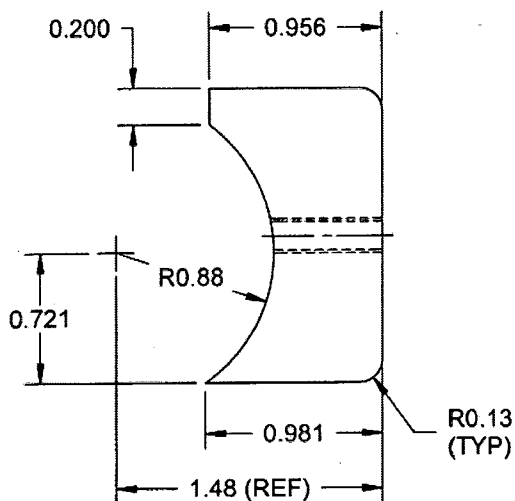
- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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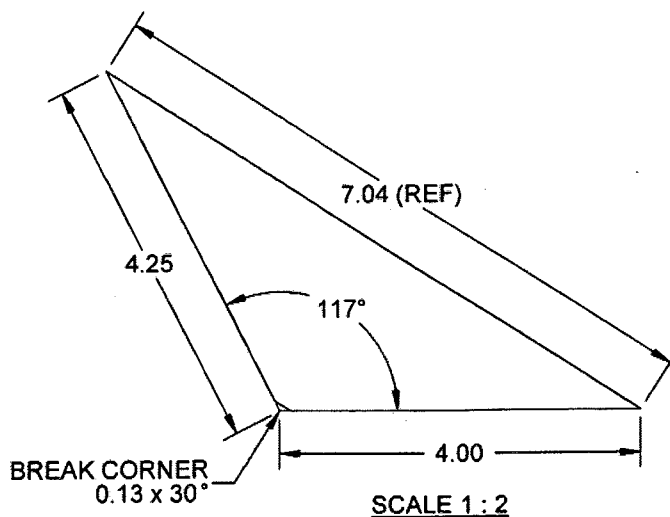
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

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*[Signature]*  
05/08/18



SCALE 1:2

**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

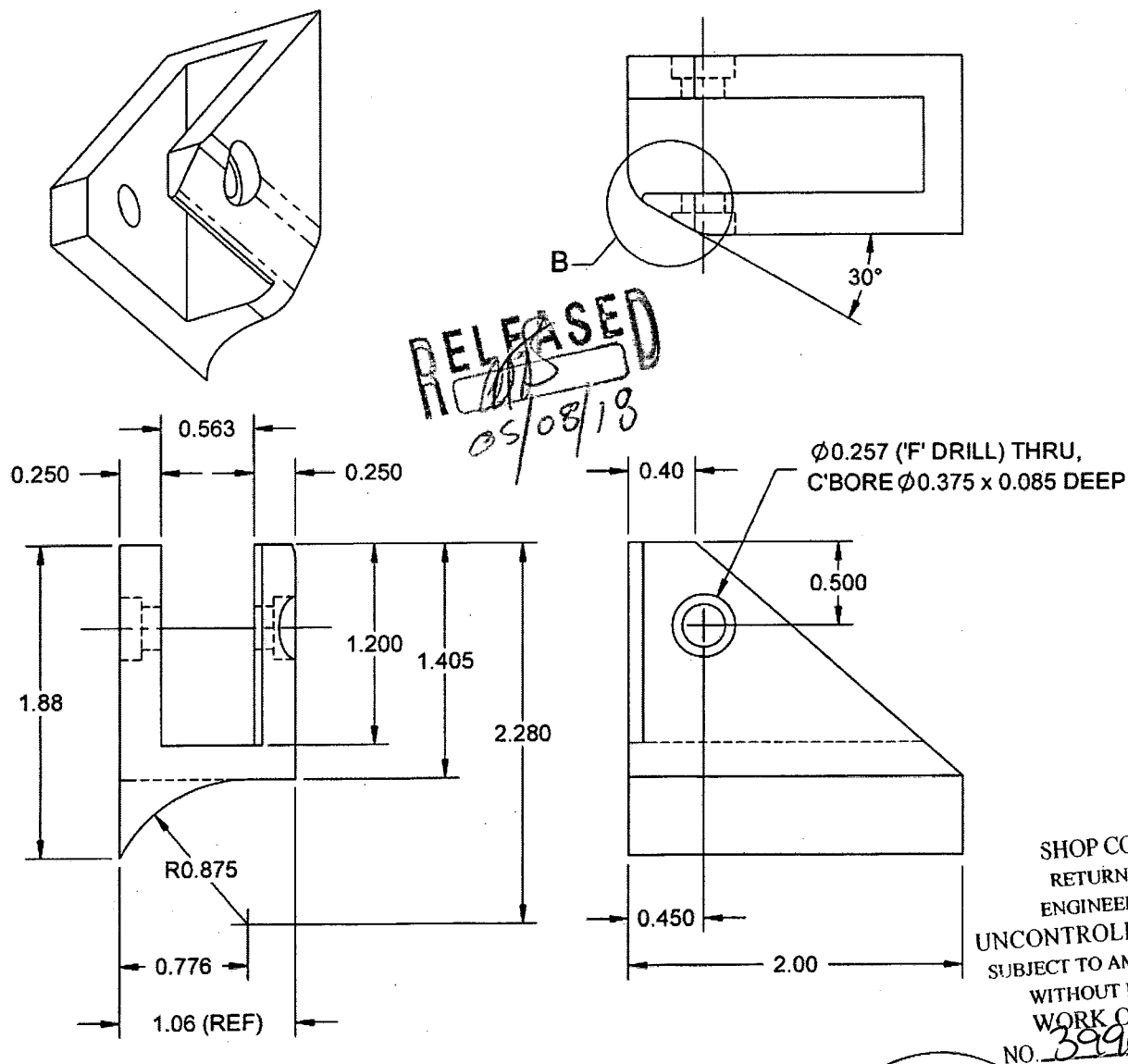
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

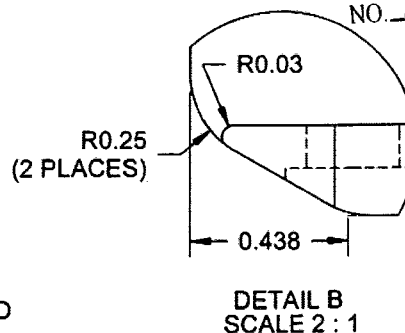


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**D3440-13 BRACKET**  
**SUPERSEDES PREMIER P/N B67-43001-273**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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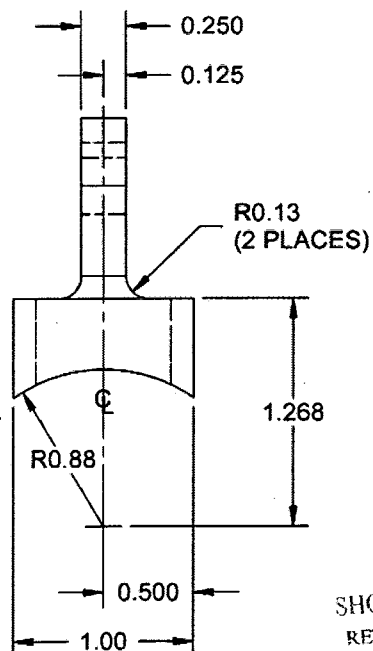
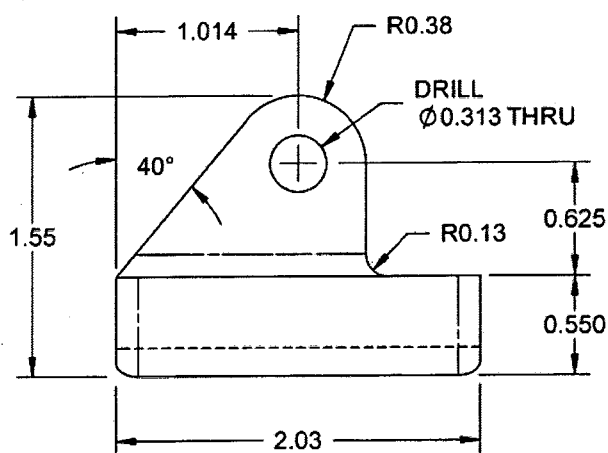
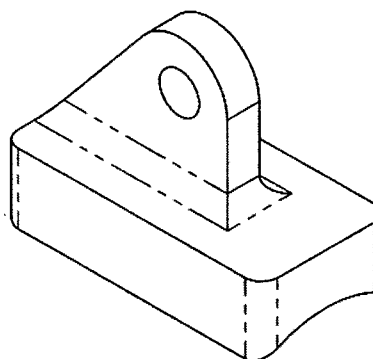
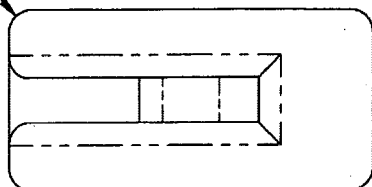


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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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*[Signature]*  
05/08/18

R0.13  
(4 PLACES)



**D3440-15 CONTOURED MALE EYE**  
**SUPERSEDES PREMIER P/N B67-43001-215**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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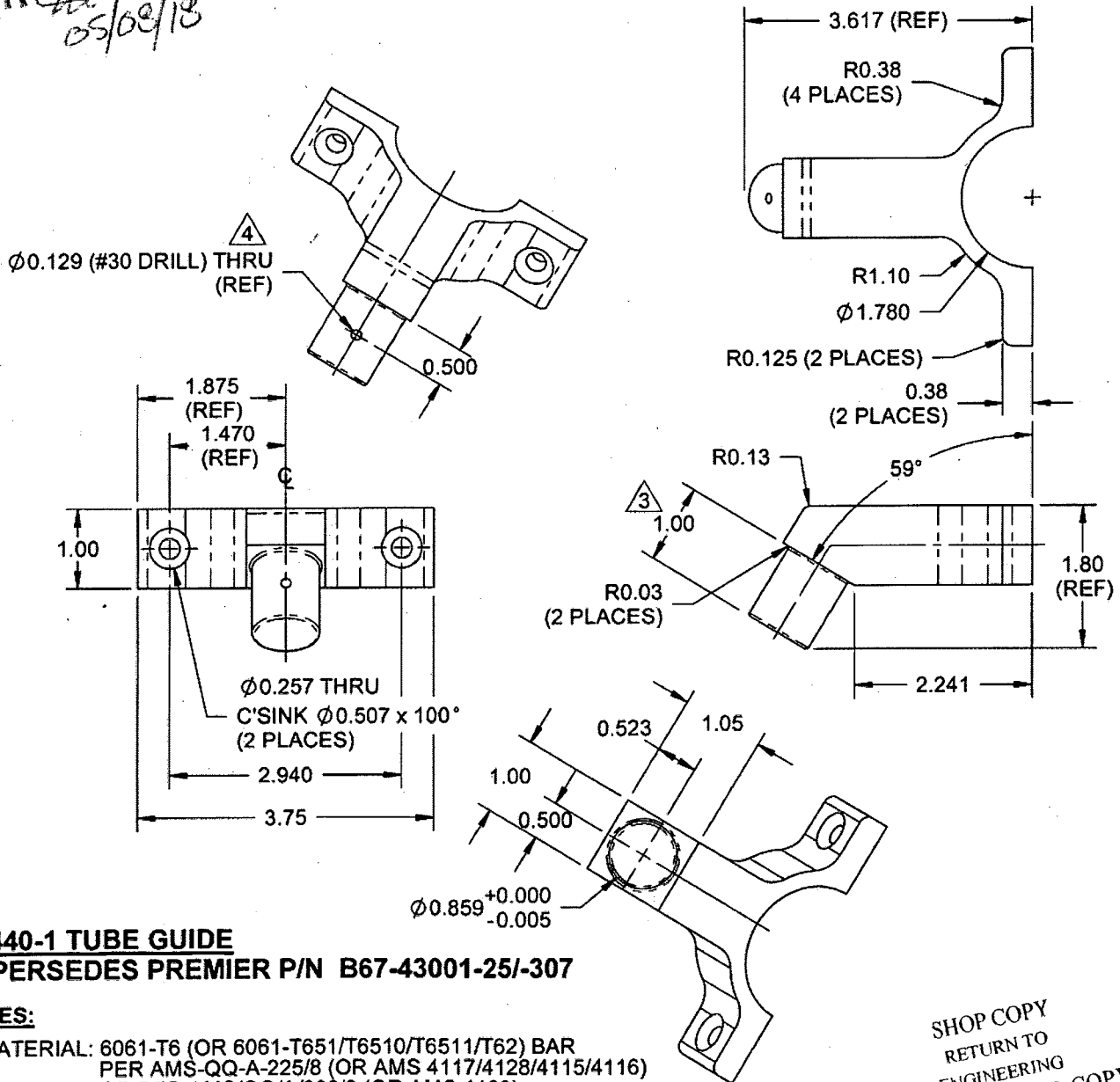
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DATE	05.06.02	TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:2
A	05.06.02	NEW ISSUE	

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05/08/18



**D3440-1 TUBE GUIDE**  
**SUPERSEDES PREMIER P/N B67-43001-25/-307**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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